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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	19416
<b>Description:</b> Bearpaw Kit (19" x 24")		<b>Part Number:</b>	K10008
<b>Dwg:</b> D2432 Rev. F3		<b>Qty:</b>	10 Kits
<b>Ref:</b> K10008 Rev. E		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler <b>Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required</b>	KJ	03.07.09	10																																																
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 <b>CHG006</b> For KJ WK 32 KJ <b>(Bag Bluefiles separately)</b>	JMC	03-08-05	10																																																
3	GA	<b>Cut 2 blanks per (1) K10008 Kit</b> Cut blank: 20.00" x 24.00" x 1.00" thick Material: Black UHMW 1" (MUHMWB10) Batch: M12812 M13307 M13578	CP	03/08/11	10																																																
4	MV	Inspect material for defects or damage prior to machining	ML	03/08/13	10																																																
5	MV	Machine as per Folio D2432 and Dwg D2432	ML	03/08/13	10																																																
6	QC2	Inspect parts as they come off the CNC machine	ML	03/08/13	10																																																
7	MV	Deburr	ML	03/08/13	10																																																
8	QC8 & 5	Second inspection	EL	03-08-19	10																																																
9	KP	<b>Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3)</b> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>6</td><td>D2182B050</td><td>Rubber Cushion</td><td>B18914</td></tr><tr><td>12</td><td>D2274</td><td>Radius Block</td><td>B19107</td></tr><tr><td>2</td><td>D2432F</td><td>24" Bearpaw</td><td>B19410</td></tr><tr><td>6</td><td>D2438</td><td>Clamp</td><td>B189105</td></tr><tr><td>12</td><td>D2529</td><td>Washer B18930</td><td>B18539</td></tr><tr><td>6</td><td>D2732-050</td><td>Rubber Cushion</td><td>B18806</td></tr><tr><td>12</td><td>AN4-15A</td><td>Bolt</td><td>M13437</td></tr><tr><td>12</td><td>AN4-17A</td><td>Bolt</td><td>M12692</td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td>M13356</td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M126020</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	6	D2182B050	Rubber Cushion	B18914	12	D2274	Radius Block	B19107	2	D2432F	24" Bearpaw	B19410	6	D2438	Clamp	B189105	12	D2529	Washer B18930	B18539	6	D2732-050	Rubber Cushion	B18806	12	AN4-15A	Bolt	M13437	12	AN4-17A	Bolt	M12692	24	AN960JD416	Washer	M13356	12	MS21042L4	Nut (or -4)	M126020	1	Paperwork package from Step 2			Q	03-08-26	10
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10	QC4	Inspect Kit for 100% Completeness on the W/O	U	03-08-26	10																																																
11	PK	Identify and pack for shipping as per PPP K10008 REV. E	Q	03-08-26	10																																																
12	AC	Cost / part 239.27	SYE	03-08-27	10																																																
13	DC	Close W/O 231.93 Inspect Level 21	U	03.08.27	-																																																

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	

Work Order:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector	

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**NOTE:** Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncb.doc

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jul 08, 2003  
01:11 pm

Work Order No	: 0019416	Department Code:	
Project Name	: *K10008	Burden Flags	: NNNNNNN
Project For	: WK333	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *K10008	Invoice Number	:
Description	: Bearpaw kit 19" x 24"	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 10	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 07-08-03	Actual Margin	: 0.000%
Est Finish Date	: 08-14-03		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Testing Hours	: 0.00	0.00	0.00		
Testing Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
SubContract Hours	: 0.00	0.00	0.00		
SubContract	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

**Dart Aerospace, Ltd**

1270 Aberdeen Street

Hawksbury, Ontario

K6A 1K7

Tel: (613) 632-3336 Fax: (613) 632-4443

Supplier Code: \_\_\_\_\_ Sheet \_\_\_\_\_ of \_\_\_\_\_

# INSPECTION CHECKLIST

PART NO.: K10008

PHY. CHANGE: NA

DESCRIPTION: Bearpaw kit

DRAWING CHANGE: Rev. F3

MANUFACTURING DATE: 03/08/13

UNICORP E.O.'S: 116A

BATCH NO.: 19416

SERIAL NO.: 214

PURCHASE ORDER NO.: N/A

QUANTITY ACCPT. \_\_\_\_\_ REJ. \_\_\_\_\_

DATA SHEET NO.: \_\_\_\_\_

☒ FIRST ARTICLE

## □ PERIODIC CONFORMITY

## □ FINAL INSPECTION

ITEM	DWG PAGE	DRAWING DIMENSION	TOL.	ACTUAL DIMENSION	ACC.	REJ.	% OF INSP.	Method of Inspection	Comments
1	1	2.000	±.010	2.000	✓		100%	Vern	
1	1	11.000	"	11.000	✓			M-Tape	
1	1	20.000	"	20.000	✓			"	
1	1	23.750	"	23.750	✓			"	
1	1	19.000	"	19.010	✓			"	
1	1	0.375	"	0.380	✓			Vern	
1	1	7.375	"	7.375	✓			M-Tape	
1	1	11.625	"	11.625	✓			M-Tape	
1	1	Ø0.260	±.008	Ø0.260	✓			Vern	
1	1	Ø0.930	"	Ø0.932	✓			"	
1	1	0.300	±.010	0.299	✓			"	
1	1	Ø0.375	"	Ø0.375	✓			R-G	
1	1	Ø0.500	"	Ø0.500	✓			"	
1	1	0.625	"	0.625	✓			Micro	
1	1	0.250	"	0.241	✓			"	
1	1	0.200	"	0.205	✓			Vern	
1	1	5.500	"	5.507	✓			"	
1	1	0.25x45°	±.020	0.240x45°	✓			"	
1	1	0.950	±.010	0.948	✓			"	
1	1	0.375	"	0.382	✓			"	
1	1	3.211	"	3.211	✓			"	
1	1	3.625	"	3.625	✓			"	
1	1	Ø0.250	"	Ø0.250	✓			R-G	

H:\admin-qa\iso\forms\first article inspectionA

Rev. B

Measured by:

Audited by:

Approved by:

03.08.13